

BOHLER FOX S EV 50-1

Stick electrode

Standard designations

unalloyed basic

EN ISO 2560-B:2005: E 49 18-1A U H5

AWS A5.1M-04: E4918-1H4R

AWS A5. 1-04: E7018-1H4R

Characteristics

- Basic covered electrode with very good welding characteristics including out of position work.
- Particular good impact properties down to -50°C.
- CTOD tested at -10°C.
- Weld metal recovery about 115%*.
- Crack-free weld metal when welding high-carbon steels.
- Suitable for use in tank construction, boiler and pressure vessel manufacturer, apparatus engineering, vehicle manufacture, offshore applications and ship building.

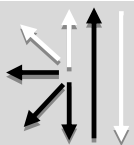
Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	P	S	Cr	Mo	Ni	Mn+Ni+Cr+Mo+V
0.08	0.50	1.40	0.009	0.01	< 0.05	< 0.05	< 0.05	1.4

Mechanical properties of all weld metal

	Yield strength MPa	Tensile strength MPa	Elongation A4 %	Impact values in J CVN	
				+20°C	-50°C
Typical	490	560	30	190	100

Operating Data



Polarity : DCEP

Note: * metal recovery rate may vary slightly with higher diameter
Re-drying if necessary: **300 – 350°C, min. 2 h.**
Electrode Identification : **Bohler Fox S EV 50-1/7018-1H4R**

Base materials

S235JRG2 – S355J2, E295, E335, C35; boiler steels P235GH, P265 GH, P295GH, P355GH; fine grained structural steels up to S420N; shipbuilding steels A, B, D, E; offshore steels; pipe steels P265, P295, L290NB – L415NB, L290MB – L415MB, X42 – X56; cast steels GS-38, GS-45, GS-52; ageing resistant steels Ast35 – Ast52; SA 516 Gr 60, 65, 70; SA333 Gr 6.

Approvals : ABS,LR,DNV,BKI,IBR

Size, Packaging & Electrical Operating Data

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 350	5.0	20.0	80 – 110
3.25 x 350	5.0	20.0	100 – 145
3.25 x 450	5.0	20.0	140 – 200
4.00 x 450	5.0	20.0	190 – 250
5.00 x 450	5.0	20.0	200 – 250

PT. voestalpine Bohler Welding Asia Pacific

“Subject to change without notice”.

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